

Report on field quality in the main LHC dipole collared coils and cold masses: September-October 2004

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This report gives data relative to field quality measured in collared coils and cold masses during the period September 1– October 31 2004, warm-to-cold correlations, comparison to beam dynamics targets, and status of the holding points. Updated graphs can be found in the field quality observatory <http://lhc-div-mms.web.cern.ch/lhc-div-mms/MMSPAGES/MA/Obs.html>.

EDMS n. 524893

The dashboard

- Available measurements:
 - 587 collared coils and 531 cold masses at room temperature,
 - 121 dipoles plus 14 half dipoles (one aperture only) for a total of 128 equivalent dipoles at 1.9 K¹.
- In these two months we had:
 - 81 new collared coils (24 from Firm1, 24 from Firm2 and 33 from Firm3) measured at room temperature,
 - 9 complete dipoles plus 2 half dipoles measured at 1.9 K.

What's new

- **Production rate** increased by 30% and is now at 40 collared coils per month. Firm1 and Firm2 speed up considerably and are now at 2.75 collared coils per week, Firm3 is at 3.8 collared coils per week.
- **Length of feedback loop:** The minimal delay between collared coil magnetic measurements and magnetic measurements at 1.9 K has again been lowered from previous record (58 days) to 50 days (obtained for magnet 1136).
- **Trends in transfer function:** Transfer function in Firm3 is back to low values comparable to Firm2, but is still 10 units higher than in Firm1. Thanks to the higher magnetic length of Firm1, we are now in an optimal situation with an extremely low spread between Firms. The situation of this parameter is usually rapidly changing during the production.
- **Trends in b3:** The situation in Firm2 is getting better. Now average b3 is in the upper part of the target range, 2 units lower than in Firm1-3. The systematic b3 (average of all Firms) is in the optimal range.
- **Trends in b5:** The situation in Firm2 is getting better. Now average b5 is within target range. The systematic b5 is at the upper edge of the target range.
- **Trends in a4:** Systematic a_4 in Firm2 is oscillating between 0 and 1 units.
- **Assembly faults:**
 - In Firm2 we still a few cases of spikes along the axis, which can be traced back to block6 movements. Since the de-collaring of a few of these magnets has shown that the defect cannot be cured, and since quench performances are good, these collared coils have been released.
 - In Firm3 we had another case of folded outer shim (magnet 3254).

¹ These numbers refers to complete measurements of either magnets or single apertures available in AT-MTM Oracle database. From this report on, we include in our analysis also complete measurements of single apertures, thanks to the code implemented by P. Hagen. On the other hand, we still do not include measurements where either the transfer function or the multipoles are missing.

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The new format of the report

We remind the reader the most important features of the report.

- The first section deals with the number of measured magnets in the last two months and the assembly data (X-section type and shim size).
- In the second section we have the summary of the measured field quality of all collared coils versus beam dynamics targets. This gives a quick overview of the best guess for the status of field quality versus beam dynamics.
- The third section is devoted to trends in field quality.
 - The trend plots show multipole moving averages for each manufacturer versus the magnet progressive number². Each marker is the average of 5 measurements:
 - the collared coil characterized by the progressive number in the horizontal axis
 - the two collared coils previously produced by the same Firm
 - the two collared coils produced afterwards by the same Firm
 - We always give plots for the collared coil measurements, except the case of bending strength where also cold masses measurements are adding important information. When comparing these cold masses to collared coils, one has to take into account that usually the last 60 collared coils have not yet become cold masses, and therefore a different pattern has to be expected in the end of the plot (see Figs. 9-10, and 11-12).
 - We give the reduction to nominal shims only for b3. Now shims are nearly always nominal.
 - Correlations are not presented in the standard plot 'warm-vs-cold', but rather as a trend plot of the offset between warm and cold vs the magnet progressive number. In this way we can visualize trends in correlations and the type of sampling that is being carried out at 1.9 K.
 - From this report on, all plots give integral values (i.e. including contribution of coil heads). This gives in some cases an offset in the y scale with respect to plots of the previous reports, corresponding to the head contribution.
- The final Section is devoted to field quality used to detect a faulty assembly procedure.

² We recall the definition of magnet progressive number, used as abscissa axis in most of our trend plots: it is a number running from 1 to 1232 which is associated to each magnet, according to the date of collaring.

PART I: MEASURED MAGNETS AND ASSEMBLY DATA

- 81 new collared coils have been measured (collared coils 507th to 587th).
 - 24 of Firm1 (1145, 1157-64, 1166-77, 1179-80, 1182).
 - 24 of Firm2 (2098, 2110-32)
 - 33 of Firm3 (3215,3251-82)

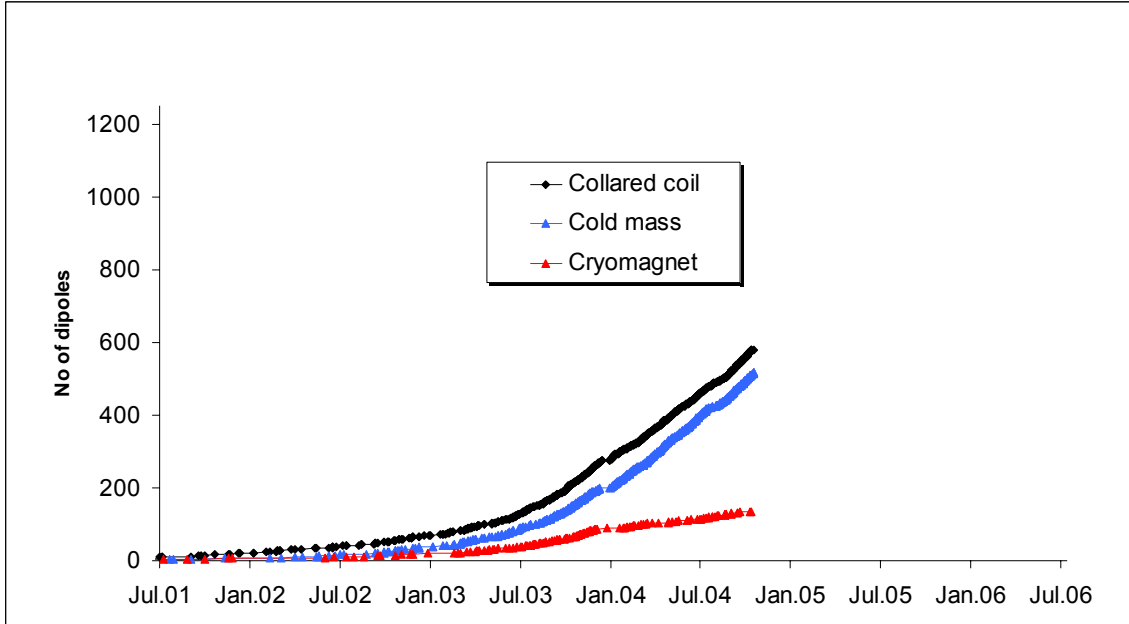


Fig. 1: Number of magnets measured at CERN at 1.9 K and at the manufacturers at room temperature at different stages of assembly procedure

- Cross-section: collared coils have X-section 3. Magnets 1133 to 1142 have cross-section 2 (i.e., no additional mid-plane insulation). Collared coil 1141 is not assembled yet.
- Shims are nominal in all Firms, except one case in Firm1. The coil size crisis of Firm1 that we had between collared coil progressive number 180 and 350 (see Fig. 2) is over.

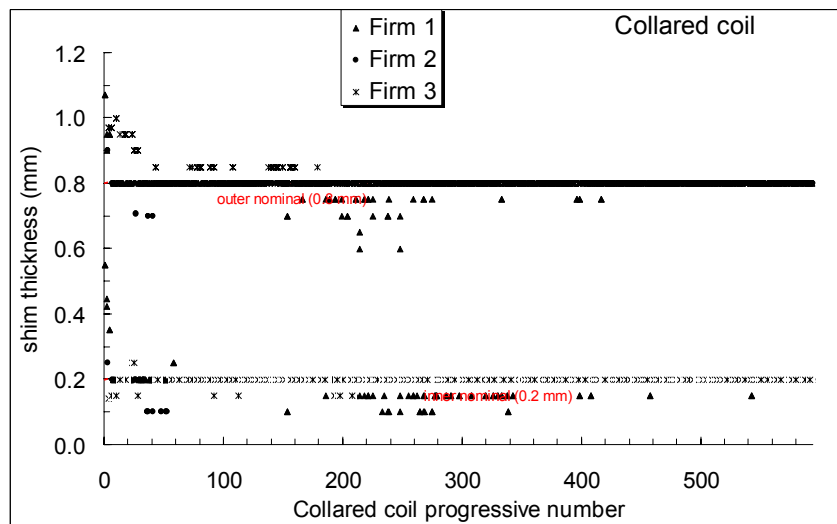


Fig. 2: Thickness of the polar shims used in the collared coils

PART II: MEASUREMENTS VERSUS BEAM DYNAMICS TARGETS

2.1 Summary of systematic components

- Best estimates of skew and even normal systematic components are given in Fig. 3. All the multipoles are within specifications. Details on trends are given in Part III.

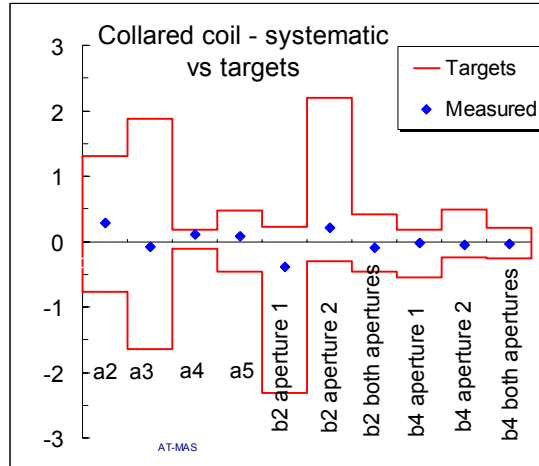


Fig. 3: Best estimate for systematic skew multipoles and even normal multipoles (markers) versus beam dynamics limits (red line).

- Best estimates for systematic odd normal multipoles are shown in Fig. 4. In the left part, raw data are plotted. This gives the actual situation for global values relative to all manufactured collared coils, which are slowly moving towards optimal ranges: b_3 is now within target and b_5 is larger than the upper target of 0.26 units.
- In the right part of Fig. 4, data are separated according to the three cross-sections (34 collared coils have cross-section 1, 147 have cross-section 2, 405 have cross-section 3, plus one hybrid 1-2). With cross-section 3, b_3 in the collared coil is within targets, 1.4 units below the upper limit (i.e., 1.8 units at high field), and also b_5 is within targets, at the edge of the upper limit (i.e., 1.18 units at injection). Finally, b_7 in the collared coil is 0.28 units larger than the limits (i.e. 0.34 units at injection).

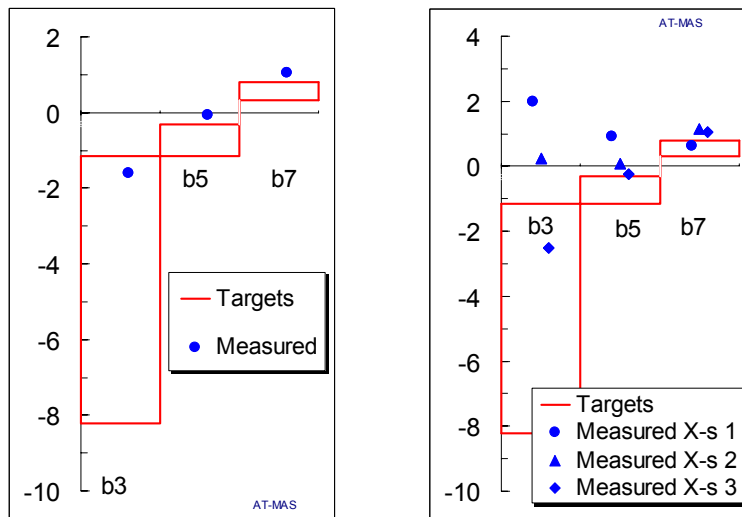


Fig. 4: Best estimate for systematic odd normal multipoles (markers) versus beam dynamics limits (red line). Raw data (left) and separated according to different cross-sections (right).

2.2 Summary of random components

- We evaluate the standard deviation of the bending strength and multipoles for all Firms and separated according to different Firms (see Fig. 5). We analyse only magnets with cross-section 3 (324 collared coils). Standard deviation of multipoles in collared coil are divided by 1.18 to give the best estimate of the random due to geometric in the cold mass, and compared to the target for the beam dynamics (**whose budget includes also the random components induced at 1.9 K**). All values are well within targets, with the exception of the main field in straight part B; please note that the relevant constraint for beam dynamics is only on the bending strength BdL, which is within targets.

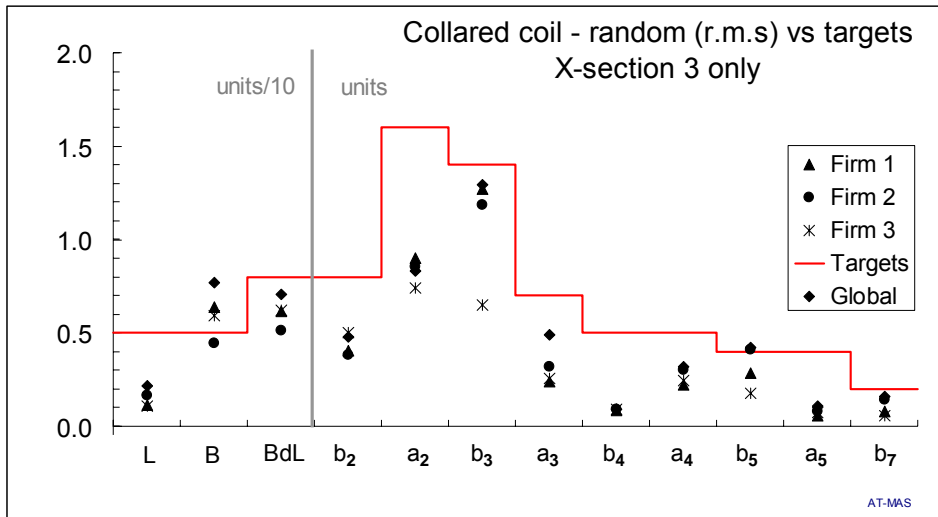


Fig. 5: Random component in the measured collared coils and rescaled to cold mass values, cross-section 3 only compared to targets for random at 1.9 K.

- In Fig. 6 we give an estimate of the actual spread due to the geometric component in the sectors of type R and L.
 - The spread of the sector R is out of target for b3 and b5. This is mainly due to the use on non-nominal shims and to the mix of X-section 1 and X-section 2.
 - In the type L sectors all values are within targets except b3 and b5. Both multipoles, which are on the edge of the target (i.e. the geometric is eating all the budget for the random at 1.9 K), are affected by the presence of 25 magnets with cross-section 2, and by the negative trend in Firm2. To reduce this spread, the possibility of installing magnets with high b3 in the second sector and with low b3 in the third one is being considered. This will also reduce the b5 spread, which has the same origin.

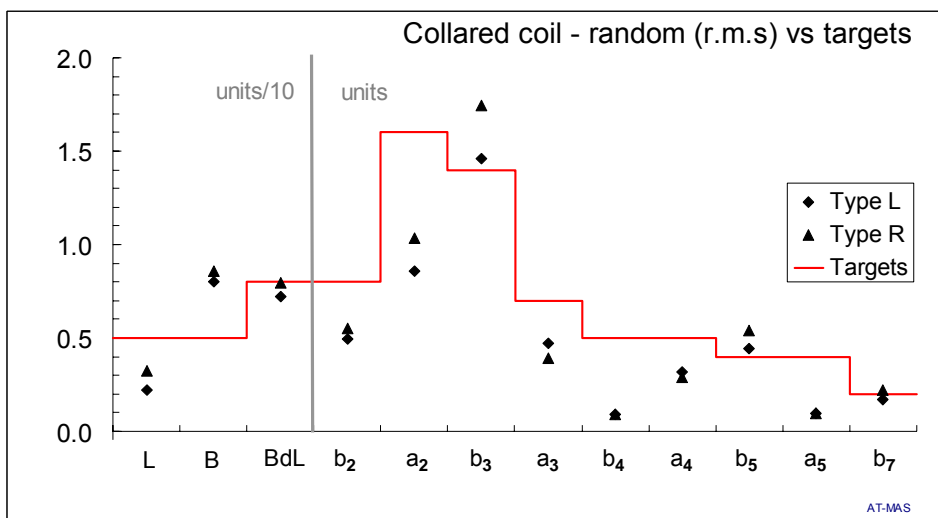


Fig. 5: Random component in the measured collared coils (rescaled to cold mass), for the first (R type) and second-third (L type) sectors, compared to targets for random at 1.9 K.

PART III: TRENDS IN FIELD QUALITY

3.1 Trends in bending strength

3.1.1 Trends in magnetic length

- Magnetic length of the collared coils is extremely stable in all Firms since magnet progressive number 100 (see Fig. 7). Magnetic length in Firm1 is 3 to 5 units higher than in Firm2 and Firm3.

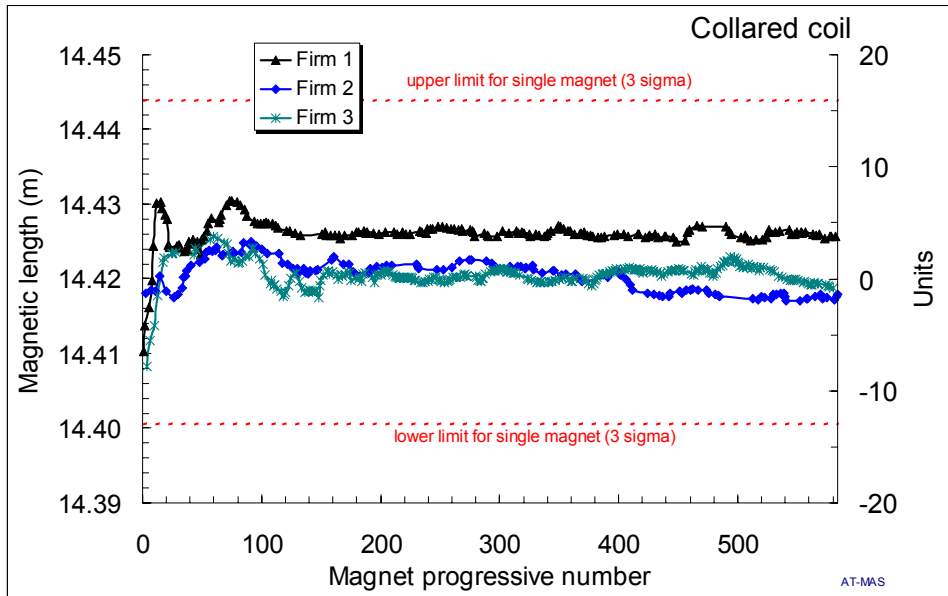


Fig. 7: Magnetic length of the measured collared coils, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm).

- Magnetic length of **cold masses** is also extremely stable in all Firms since magnet progressive number 100 (see Fig. 8). When iron laminations are added, magnetic length in Firm3 is getting smaller than in Firm1 and 2. The net result is that there are around 8 units of difference between Firm1 and Firm3. Firm2 is in between, and is converging to values of Firm3 in the more recent production.

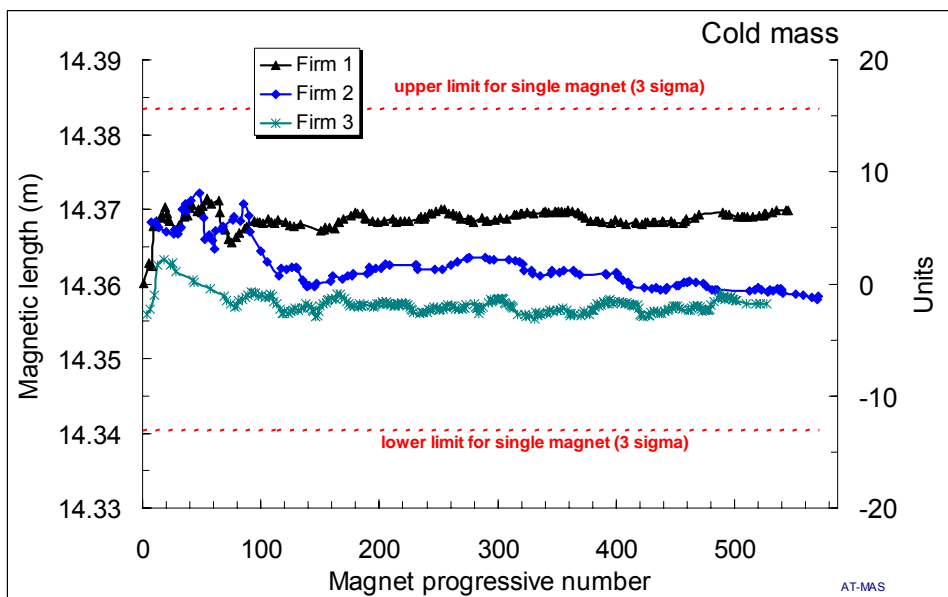


Fig. 8: Magnetic length of the measured **cold masses**, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm).

3.1.2 Trends in transfer function

- Transfer function in collared coils 507th to 587th is rather stable in all Firms. Firm2 and Firm3 are on similar values, whereas Firm1 is 10 units less (see Fig. 9).

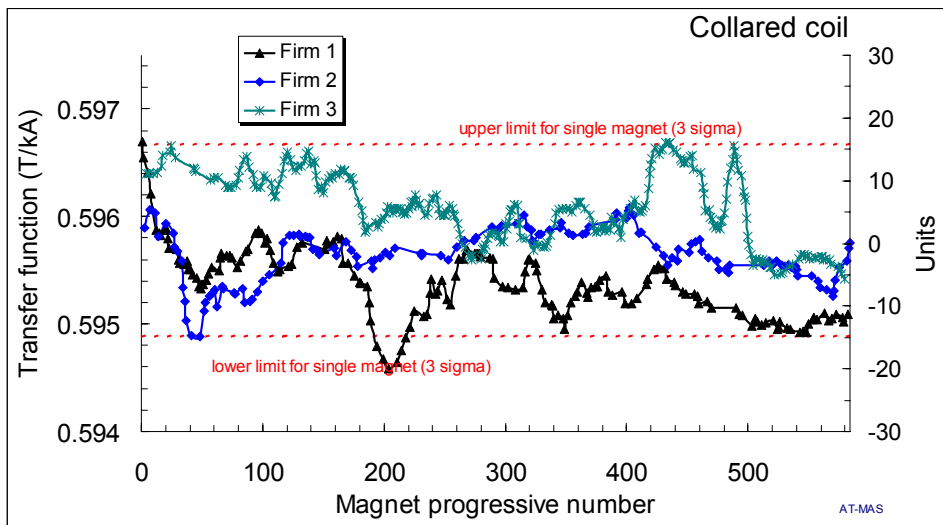


Fig. 9: Transfer function of the measured collared coils, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm).

- The systematic difference in the transfer function between Firms observed in collared coils is confirmed, but reduced of around 20% (i.e., the iron yoke contribution), in **cold mass** data (see Fig. 10).

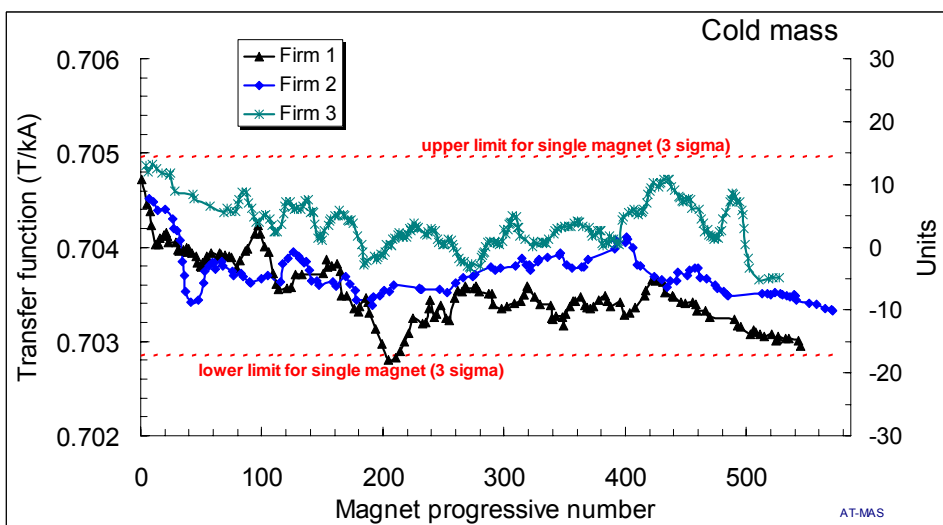


Fig. 10: Transfer function of the measured **cold masses**, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm).

3.1.3 Trends in integrated transfer function

- Due to the compensation between the lower transfer function in Firm1, and the longer magnetic length, the integrated transfer function shows a spread between Firms of at most 10 units in recent production (see Fig. 11). Values of recent production are somewhat lower (about 5 units) of what observed previously.

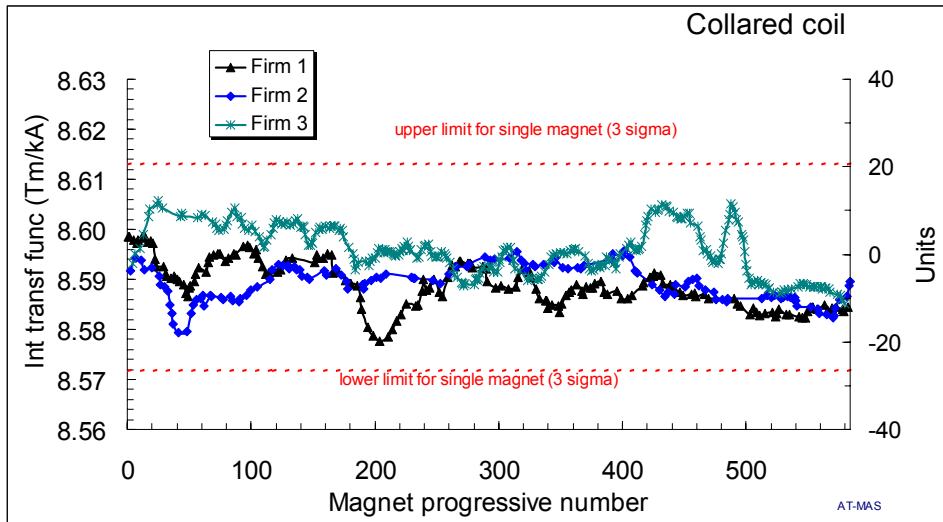


Fig. 11: Integrated transfer function of the measured collared coils, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm).

- In the **cold masses** data the spread of the integrated transfer function between Firms is reduced by 20% (see Fig. 12).

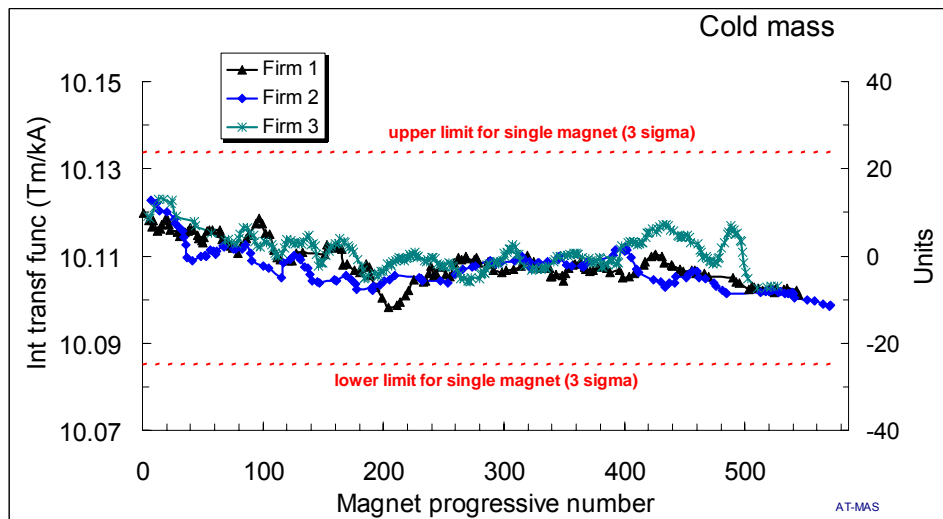


Fig. 12: Integrated transfer function of the measured **cold masses**, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm).

3.2 Trends in odd normal multipoles

- The negative trend of average b3 in Firm2 has been recovered. Average b3 in Firm2 is now around -3.5 units, and 2 units more in Firm1 and Firm3.
- We remind the reader that the peak in Firm1 collared coils around magnet progressive number 430 is due to the additional cross-section 2 magnets.

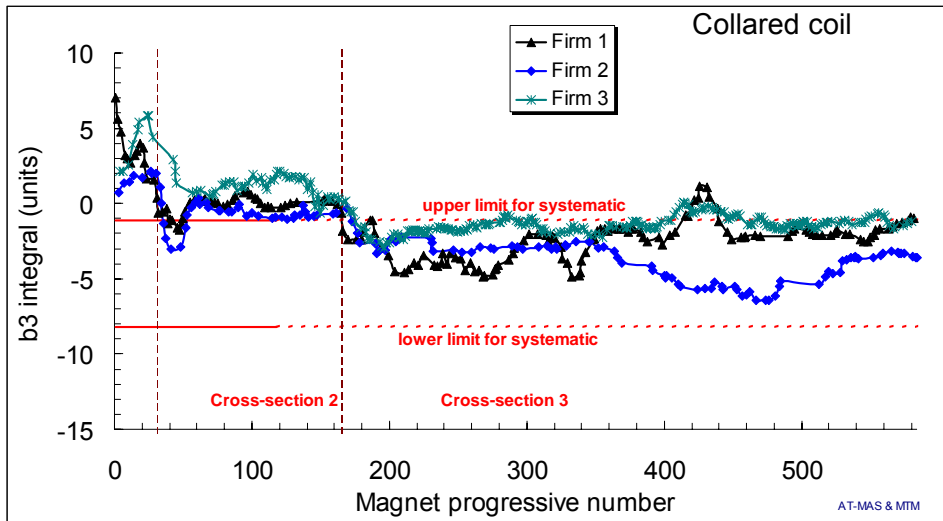


Fig. 13: Average b3 in straight part of the collared coils, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

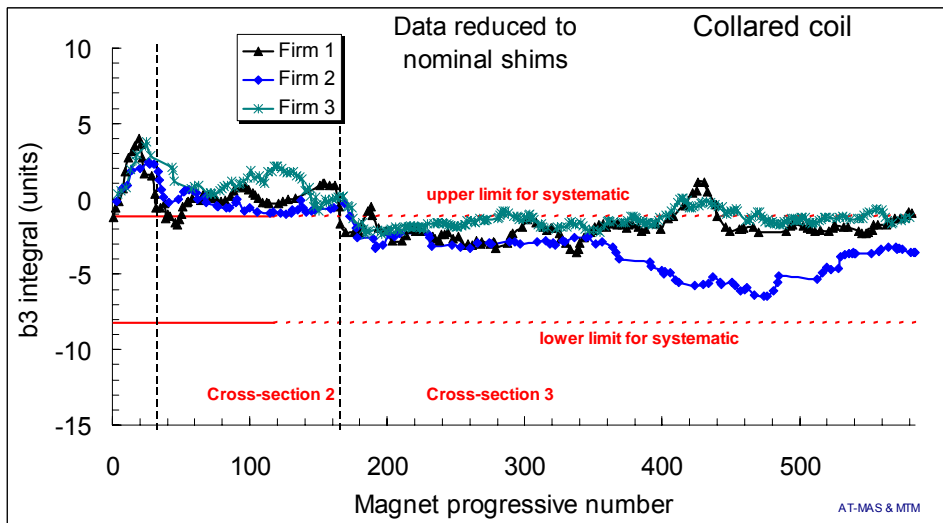


Fig. 14: Average b3 in straight part of the collared coils, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles. Data reduced to nominal shims

- The positive trend of b_5 in Firm2 observed between 380th and 520th has disappeared. Measured b_5 in Firm2 is now -0.4 to -1.0 units, i.e. within targets (see Fig. 15).
- Average b_5 in Firm3 is around -0.6 units, i.e. within targets.
- Average b_5 in Firm1 is around 0.3 units, i.e. around 1 unit more than in Firm2 and Firm3.
- Systematic b_5 in the recent production is around 0.4 units, i.e. within target but on the upper side.

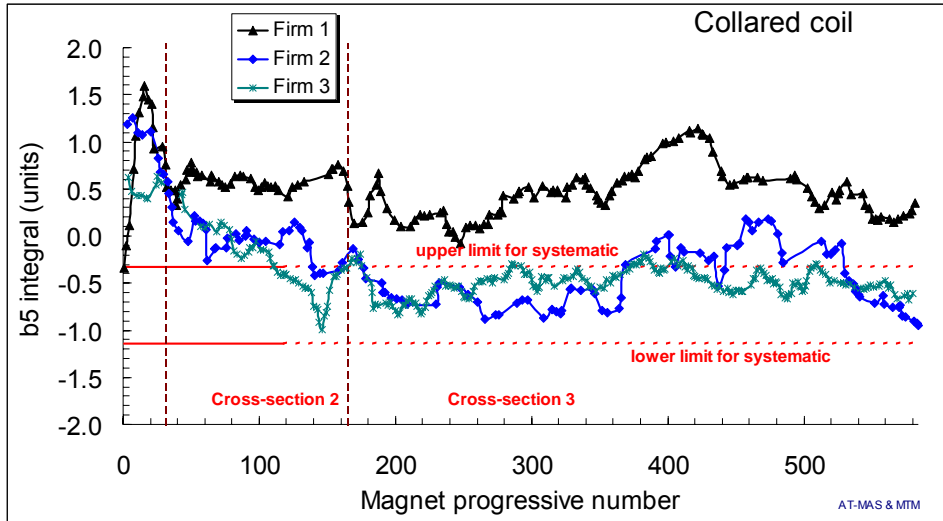


Fig. 15: Average b_5 in straight part of the collared coils, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

- Normal 14th pole b_7 is always at maximal values in Firm1 and 3 (see Fig. 16). In particular, we observe a jump in Firm3 of 0.1 to 0.2 units around magnet progressive number 500.
- In Firm2 we have a positive trend of b_7 from magnet progressive number 520, with a jump of 0.2 to 0.3 units.

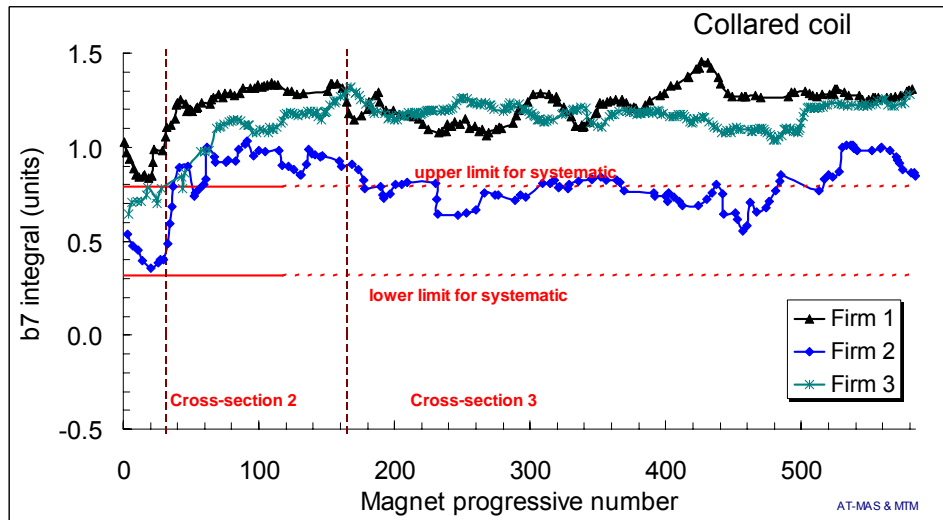


Fig. 16: Average b_7 in straight part of the collared coils, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

3.3 Trends in even normal multipoles

For each multipole being subject to beam dynamics specifications, we present two separated plots for the systematic per aperture, plus a plot of the systematic per beam, i.e. the average of both apertures (that should be zero due to the two-in-one symmetry).

3.3.1 Trends in normal quadrupole

- The systematic per aperture is in the upper (lower for aperture 2) part of the target range (see Figs. 17 and 18).

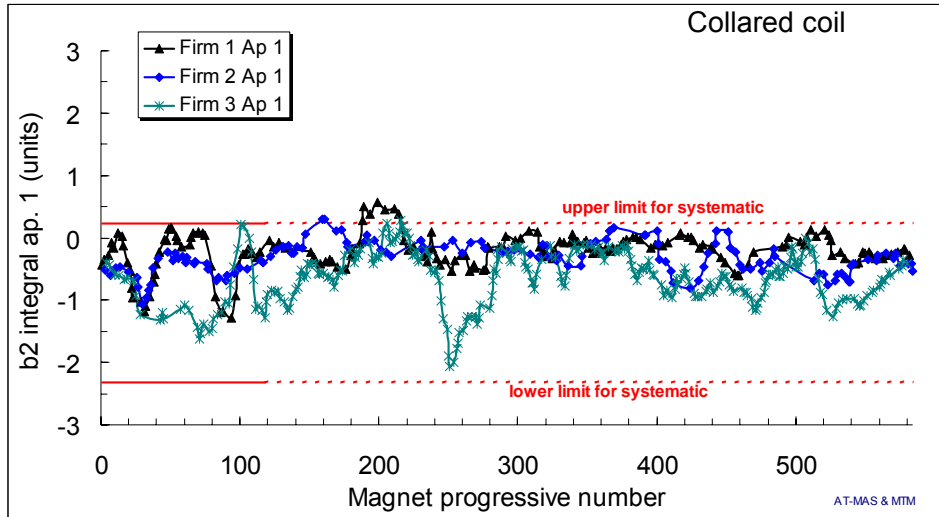


Fig. 17: Average b_2 in straight part of the collared coils (Aperture 1), separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

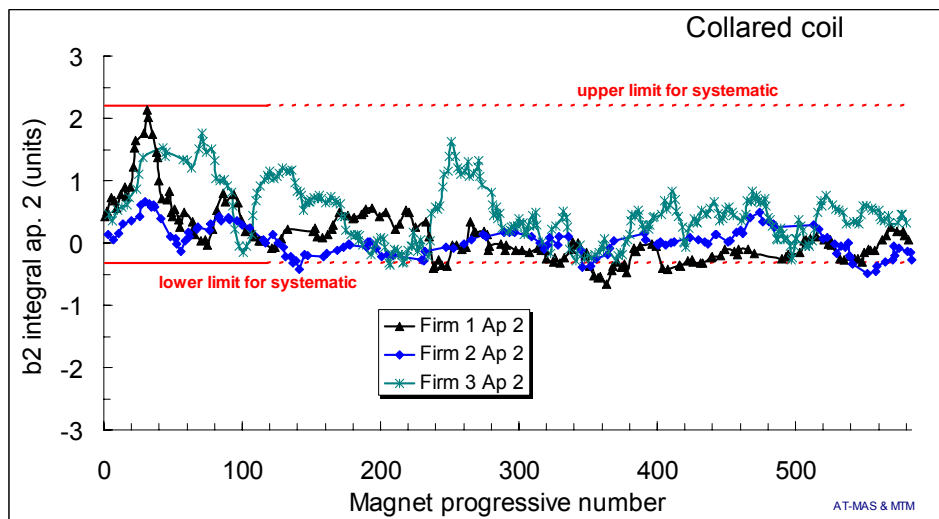


Fig. 18: Average b_2 in straight part of the collared coils (Aperture 2), separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

- The systematic normal quadrupole per beam is within specifications (see Fig. 19).

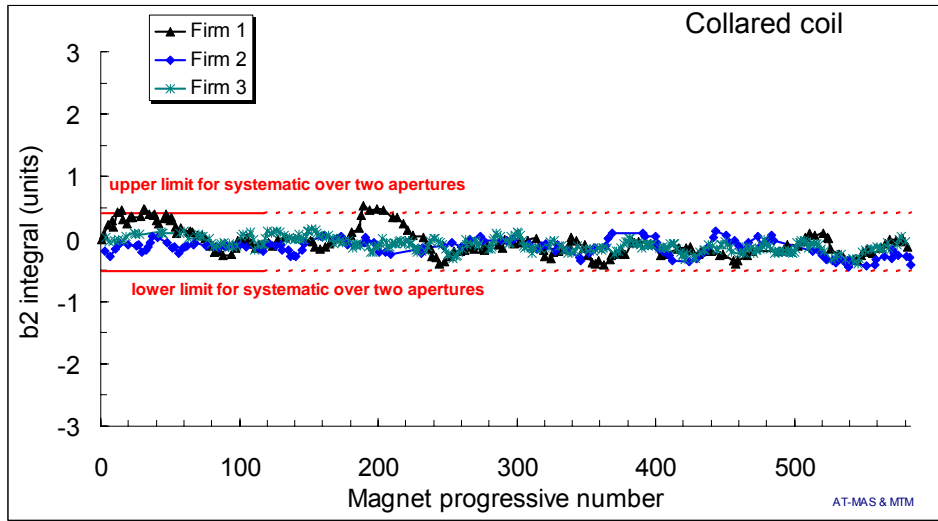


Fig. 19: Average b_2 in straight part of the collared coils (both Apertures), separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

3.3.2 Trends in normal octupole

- The systematic per aperture is within specifications in both apertures (see Figs. 20 and 21).
- The systematic per beam is also within specifications (see Fig. 22).

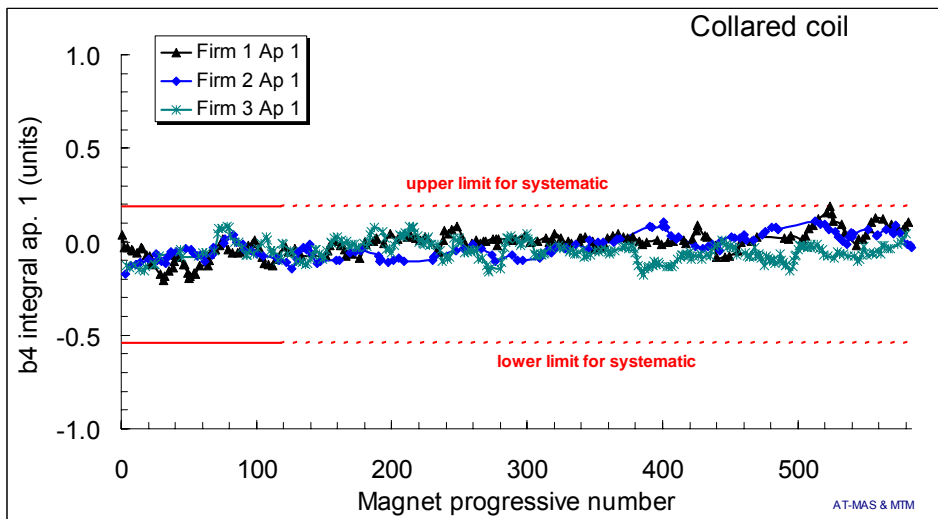


Fig. 20: Average b_4 in straight part of the collared coils (Aperture 1), separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

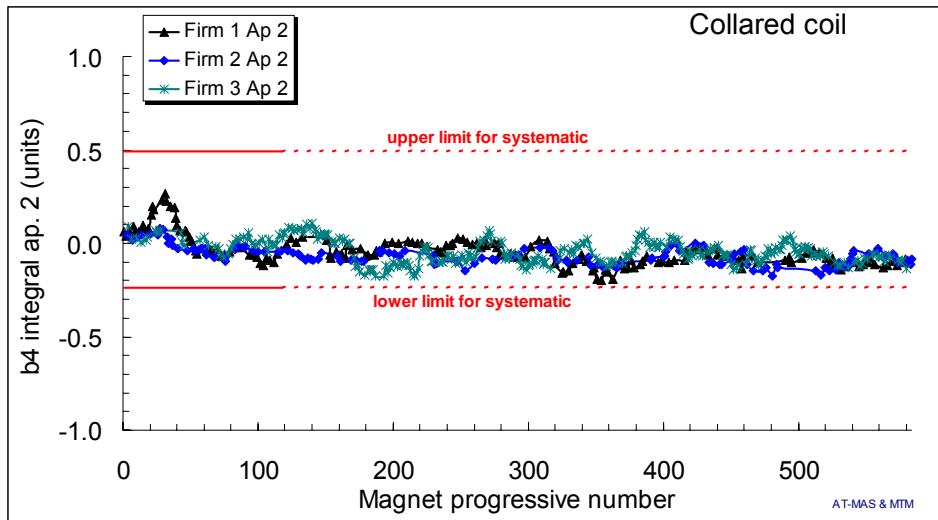


Fig. 21: Average b_4 in straight part of the collared coils (Aperture 2), separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

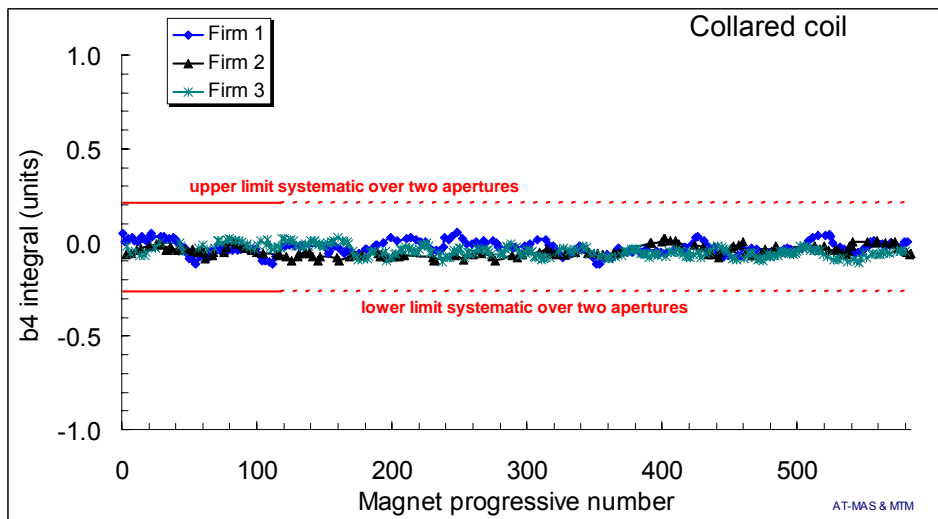


Fig. 22: Average b_4 in straight part of the collared coils (both Apertures), separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

3.4 Trends in skew multipoles

- Skew quadrupole a_2 is well within targets, and no trends are observed (see Fig. 23).

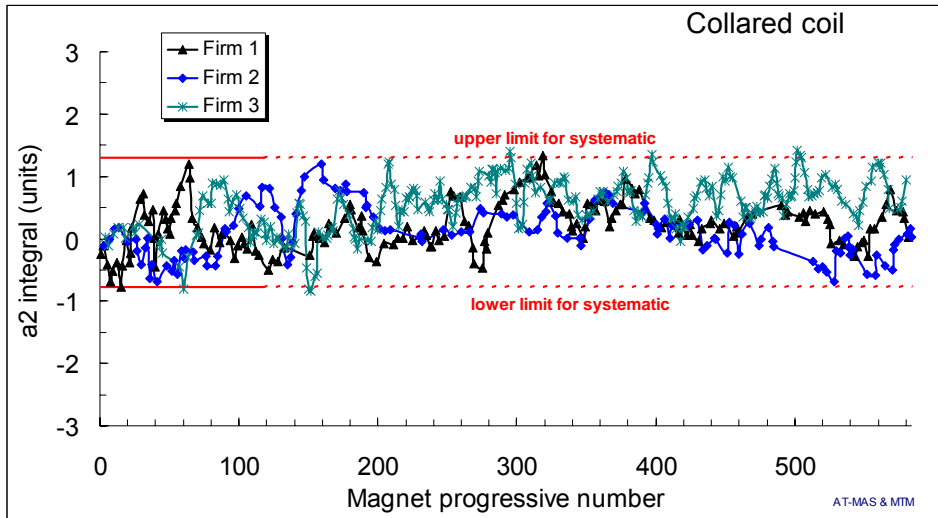


Fig. 23: Average a_2 in straight part of the collared coils, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

- Skew sextupole a_3 is well within targets (see Fig. 24). There is a positive systematic component in Firm3 (around 0.5 units), and a slightly negative component (around 0.25 units) in Firm1 and Firm2. Indeed, beam dynamics targets are very loose, and therefore there is no concern on this multipole.

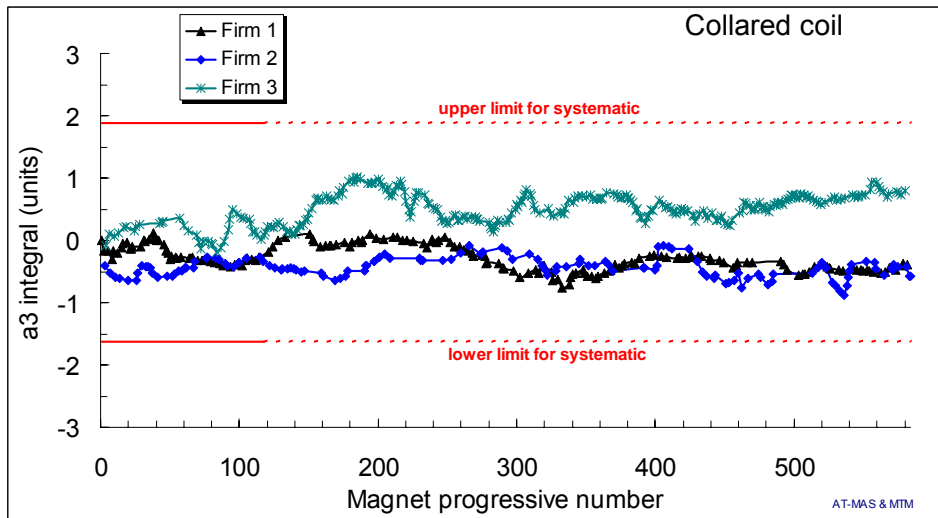


Fig. 24: Average a_3 in straight part of the collared coils, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

- Skew octupole a_4 is within the tight beam dynamics targets in Firm1 (see Fig. 25).
- The strong systematic component in Firm2 has vanished recently, and now it is growing again (see Fig. 25, around magnet 560). Indeed, this has already been observed around magnet 240.
- The strong systematic a_4 in Firm2 is partially compensated by negative values in recent production of Firm3.

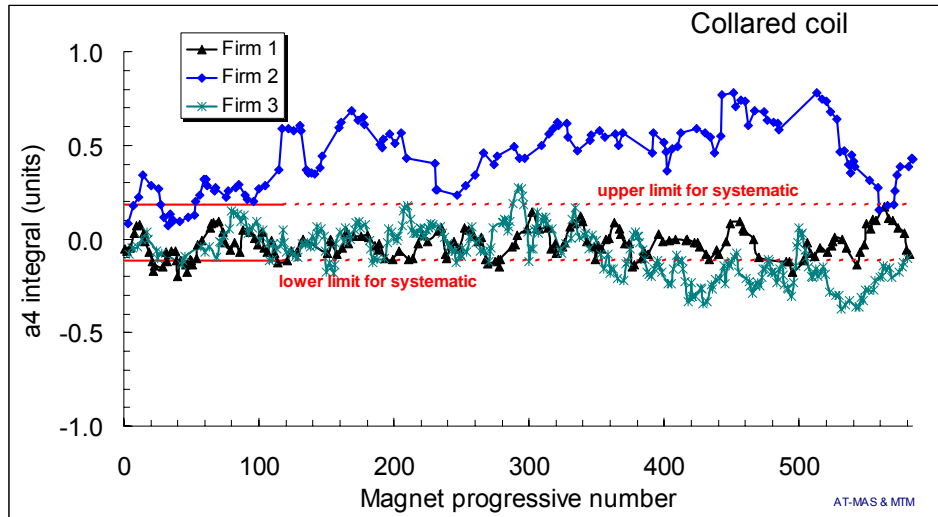


Fig. 25: Average a_4 in straight part of the collared coils, separated per Firm (each dot is average of 5 consecutive magnets of the same Firm), and beam dynamics targets for the systematic (red lines) based on correlations with 128 cryodipoles.

3.5 Trends in systematic differences between Firms

The more relevant signature of Firms is in b_7 and a_3 .

- Normal 14th pole: b_7 at Firm2 is 0.4 units lower than Firm3 and Firm1 (see Fig. 16). This difference is three times the natural sigma within the same manufacturer measured in cross-section 3. Firm2 is within targets, whereas both Firm1 and Firm3 are outside.
- Skew sextupole a_3 : Firm3 has a systematic a_3 of 0.5 units, against -0.5 units in Firm1-2 (see Fig. 24). This difference is three times the natural sigma within the same manufacturer. All Firms are within targets

On the more recent collared coils we observe some systematic difference between Firms in b_3 :

- Normal sextupole: b_3 at Firm2 is 2 units lower than at Firm1-3. All Firms are within targets, but Firm2 is placed in the central part of the range, and Firm1-3 on the upper edge. The difference between Firm1-3 and Firm2 is 2 times the natural sigma within the same manufacturer.

We observe a small systematic difference between Firms (from one to two times the natural sigma within the same manufacturer) in the following cases.

- Normal decapole b_5 : Firm1 has a systematic b_5 of 1 unit larger than Firm2-3. This difference is two times the natural sigma within the same manufacturer (see Fig. 15). Firm2-3 are within targets, whereas Firm1 is outside.
- Skew octupole a_4 : Firm2 has a systematic a_4 of 0.4 units, against -0.03 and -0.05 units in Firm3 and Firm1 respectively (see Fig. 25). This difference is equal to the natural sigma within the same manufacturer. Firm1 and Firm3 are within targets, whereas Firm2 is outside.

Systematic differences between Firms are small or negligible in a_2 , b_2 and b_4 .

3.5 Trends in correlations to measurements at 1.9 K

We give plots of the offsets between the values measured at injection field (or high field) at 1.9 K, without beam screen, and the straight part of the collared coil at room temperature rescaled by 1.18. The offsets are given versus the magnet progressive number. This gives a hint on the type of sampling of the production that is being carried out with the measurement at 1.9 K. The last magnet measured at 1.9 K is collared coil 483rd, thus implying a delay of 104 collared coils with respect to the last manufactured collared coil (i.e. the 587th), which corresponds to two months and a half of production.

- Trend plots for the offsets relative to the integrated transfer function are given in Figs. 26 and 27, at injection and at high field respectively. In both cases no trends are visible after collared coil 100th.

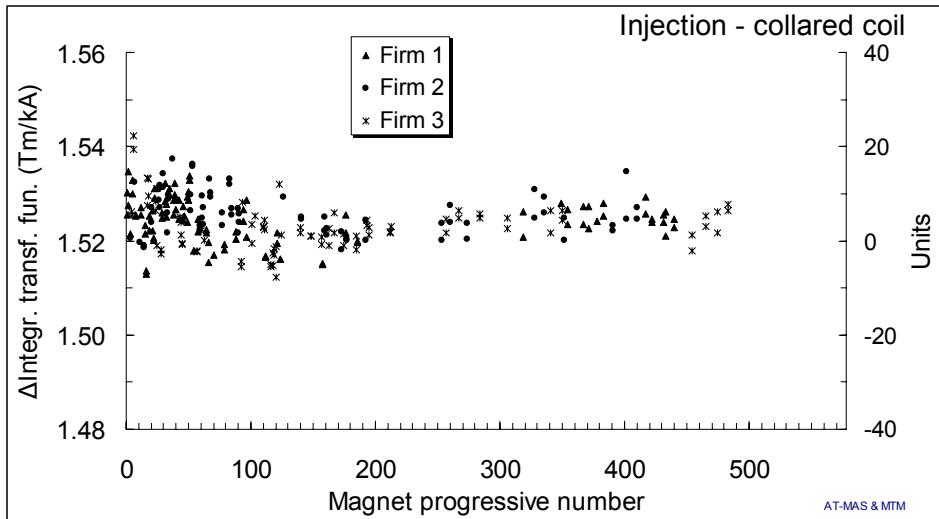


Fig. 26: Difference for the integrated transfer function between measured values at 1.9 K, injection field, and collared coil along the magnet production.

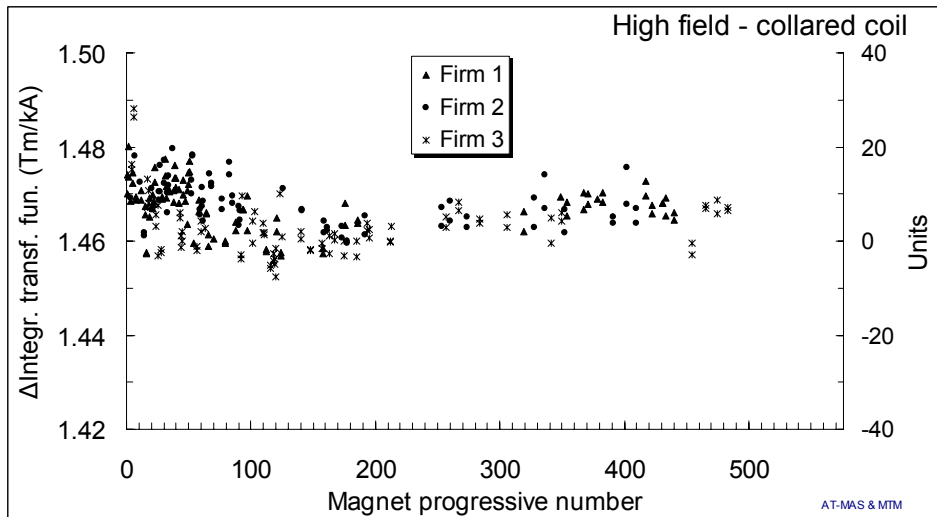


Fig. 27: Difference for the integrated transfer function between measured values at 1.9 K, high field, and collared coil along the magnet production.

- We present data relative to b3-injection and b3-high field in Figs. 28 and 29. Please note the enlarged scale with respect to b3 plots in Figs. 13 and 14. One observes a small reduction (in absolute value) of the b3 offset in the first 100 magnets at injection. In the recent data we have a Firm3 magnet with a smaller value (around -3.5 units) of the offset. At high field (which is the critical quantity for the beam dynamics) the offset is very stable (within 1 unit).

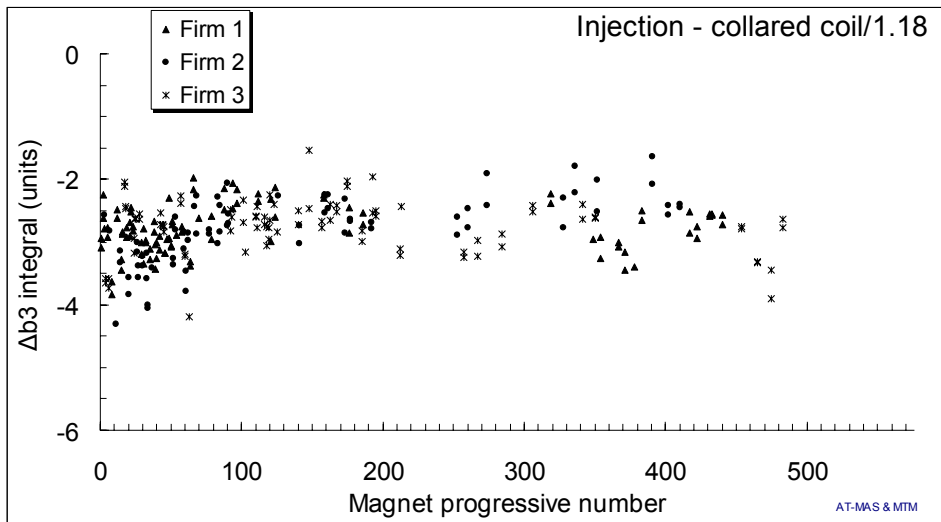


Fig. 28: Difference for the b3 between measured values at 1.9 K, injection field, and collared coil **integral** divided by 1.18, along the magnet production.

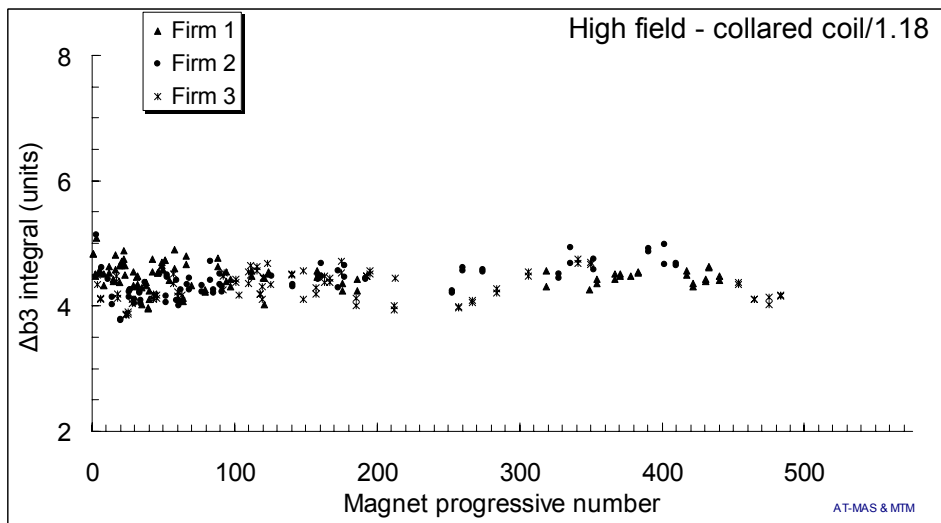


Fig. 29: Difference for the b3 between measured values at 1.9 K, high field, and collared coil **integral** divided by 1.18, along the magnet production.

- Trends for the b5 and b7 offsets between injection and collared coil straight part are given in Fig. 30 and 31. One observes a reduction (in absolute value) of the b7 offset in the first 100 magnets, whereas the b5 offset is stable.

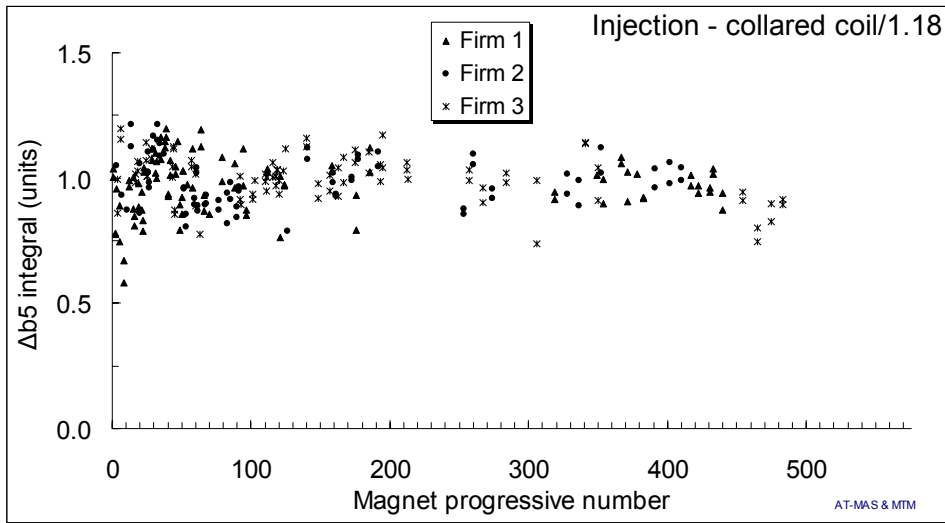


Fig. 30: Difference for the b5 between measured values at 1.9 K, injection field, and collared coil **integral** divided by 1.18, along the magnet production.

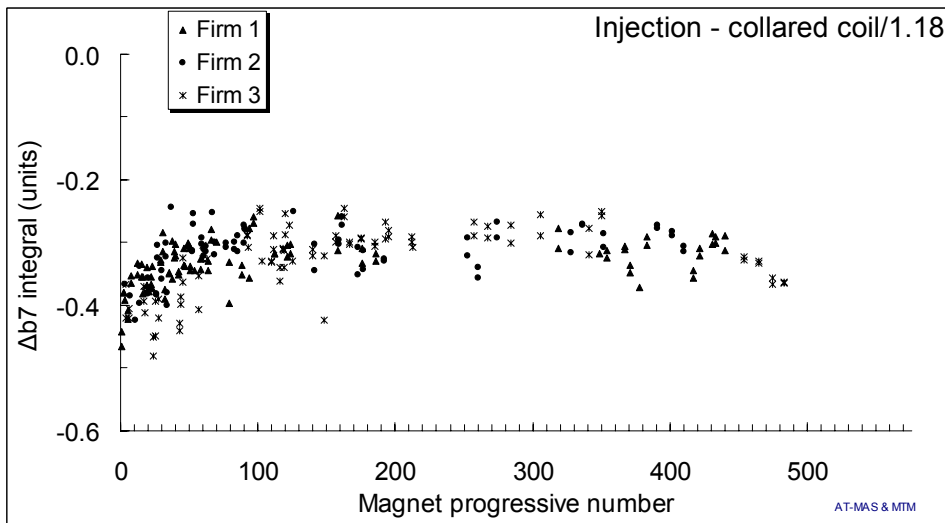


Fig. 31: Difference for the b7 between measured values at 1.9 K, injection field, and collared coil **integral** divided by 1.18, along the magnet production.

PART IV: QUALITY CONTROL

4.1 Holding point results

We had the following cases of field anomalies

- 1108 after being opened for a strong anomaly along the axis on a2, it has been re-collared since no visible defect has been found. The second collaring shows the same peak, plus an increase in average b5 as usually observed after re-collaring, and some more spikes along the axis. It has been released with warning.
- In Firm2 we had a few more cases of peaks along the axis indicating a block6 movement, that were not de-collared on the basis of the experience acquired on previous cases.
- 3254 has been de-collared for a field anomaly very similar to the case of 3125 (folded outer shim). In fact, a folded outer shim has been found exactly as for 3125.

A summary of the magnets de-collared for anomalies in the magnetic field over all the production is given in Table I. The total number of found defects is 13 over 587 collared coils, i.e. 2.2%. A large fraction of these defects (8 over 13) has been found in collared coil 300th to 400th (see Fig. 32). The situation is improving in the more recent production.

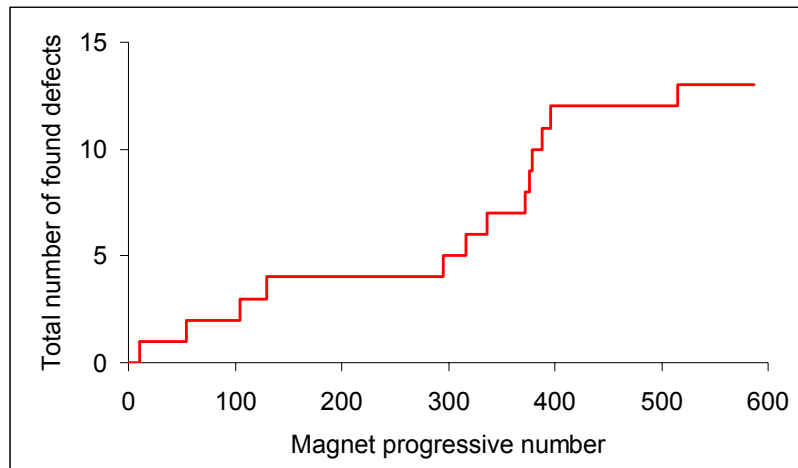


Fig. 32: Total number of defects found with magnetic measurements versus magnet progressive number.

Table I: Summary of magnets decollared on the basis of anomalies in magnetic field.

Bad assembly cases				
Magnet	Measured on	Analysis	Opened on	Result
2002	16-Jul-2001	Spike in main field	17-Jul-2001	Double coil protection sheet
1027	29-Oct-2002	Missing outer shim	01-Nov-2002	Missing outer shim
3135	27-Jan-2004	Inward movement of block5 and 6	17-Feb-2004	Folded outer shim
1108	22-Apr-2004	Missing or additional thickeness on outer pole	12-Jul-2004	No visible defect
3254	06-Sep-2004	Inward movement of block5 and 6	14-Sep-2004	Folded outer shim
Bad quality of the coil gluing				
Magnet	Measured on	Analysis	Opened on	Result
2032	21-May-2003	Inward movement of block6	18-Nov-2003	Block6 detached from inner layer
2035	14-Jul-2003	Inward movement of block6	27-Apr-2004	Block6 detached from inner layer
1099	20-Feb-2004	Inward movement of block6	16-Mar-2004	Block6 detached from inner layer
3175	20-Apr-2004	Inward movement of block6	11-May-2004	Block6 detached from inner layer
1108	22-Apr-2004	Inward movement of block6	12-Jul-2004	Block6 detached from inner layer
1122	23-Apr-2004	Inward movement of block6	24-May-2004	Block6 detached from inner layer
1128	03-May-2004	Inward movement of block6	05-Jul-2004	Block6 detached from inner layer
1130	10-May-2004	Inward movement of block6	14-Jul-2004	Block6 detached from inner layer
Other				
Magnet	Measured on	Analysis	Opened on	Result
2065	15-Mar-2004	Inward movement of block6	29-Apr-2004	Good glue, movement observed
2089	18-May-2004	Inward movement of block6	01-Jun-2004	Good glue, no movement observed
2084	10-May-2004	Inward movement of block6	09-Jun-2004	Good glue, small movement observed

4.2 Estimated coil waviness

- Coil waviness estimated from the variation of the multipoles along the axis is in general below 30 microns. For Firm2 we only have one case of high waviness (magnet 530th, corresponding to 2098). The recent part of the production is very stable, showing waviness below 25 microns.
- The crisis between collared coils 390th and 480th, due to inward radial movements of block6 in some spots along the magnet axis in Firm2 and Firm1, is now over (see Fig. 33).

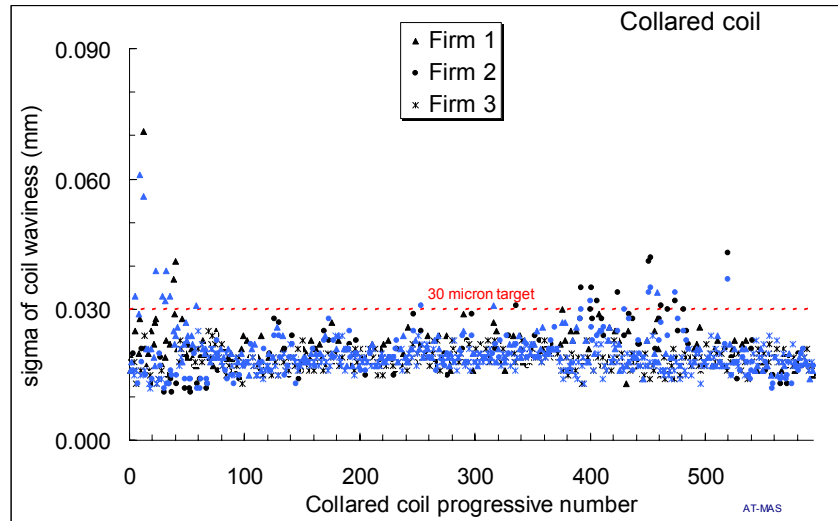


Fig. 33: Estimated coil waviness in the straight part of the measured collared coils (black dots: aperture 1, blue dots: aperture 2).

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